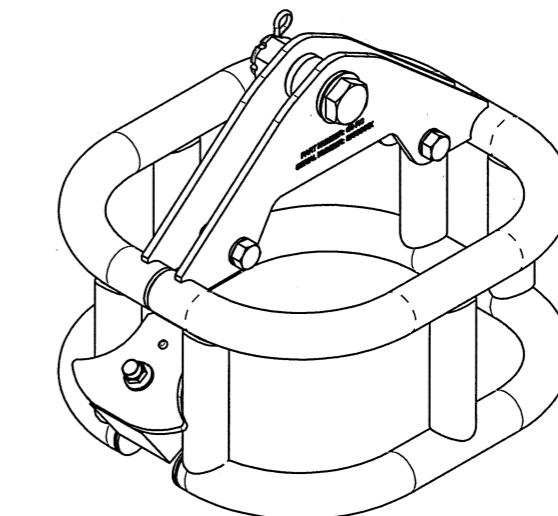
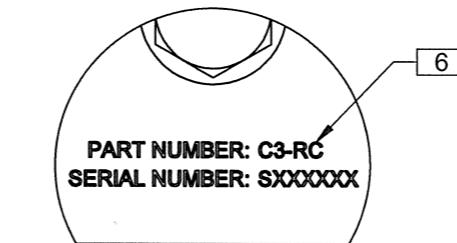
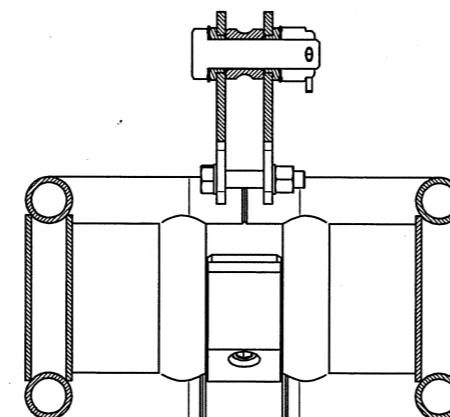
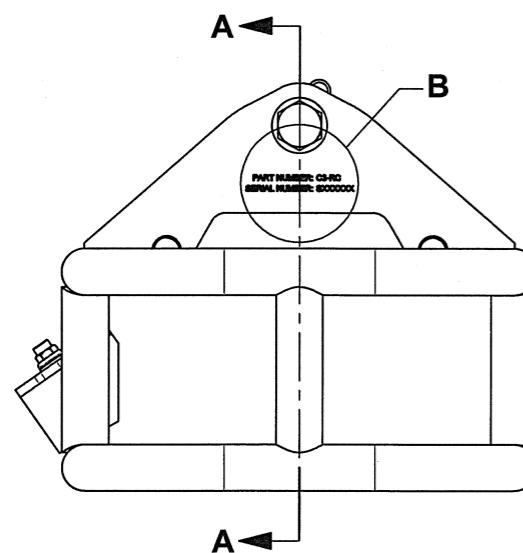
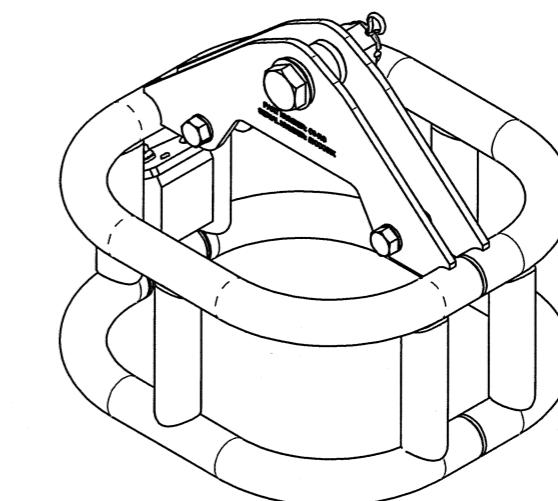


ITEM #	QTY	PART #	PART TITLE
-1	1	C3-RC-1	C3 RING CAGE WELDMENT
2	1	C3-C-8	LIFTING BUSHING
3	1	C3-C-15	BUMPER ASSY
4	2	AN6-17A	CAD. PLATED STEEL HEX BOLT 3/8"-24 X 1.313" GRIP LG. X 1.953" LG.
5	1	AN10-22	CAD. PLATED STEEL HEX BOLT 5/8"-18 X 1.438" GRIP LG. X 2.391" LG.
6	1	AN310-10	CAD. PLATED STEEL CASTELLATED HEX NUT 5/8"-18 X 23/32" HT.
7	1	MS21042-6	CAD. PLATED STEEL SELF-LOCKING NUT 3/8"-24 X 0.275" HT.
8	2	MS21044N6	CAD. PLATED STEEL SELF-LOCKING HEX NUT 3/8"-24 X 0.394" HT.
9	1	MS24665-355	CAD. PLATED STEEL COTTER PIN 1/8" DIA. X 1-1/4" LG.
10	6	NAS1149F0663P	CAD. PLATED STEEL WASHER 0.390" ID. X 0.625" OD. X 0.063" THK.
11	2	NAS1149F1032P	CAD. PLATED STEEL WASHER 0.640" ID. X 1.188" OD. X 0.063" THK.
12	1	NAS1351-6-28	BLACK OXIDE STEEL SOCKET HEAD CAP SCREW 3/8"-24 X 1.75" LG.



SECTION A-A

DETAIL B

C3-RC C3 RING CAGE

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: X-TENSION STAMP T/N AND S/N, AS SHOWN, PER QSI 044 SECTION 6.2
- 7) ASSEMBLE AS SHOWN
- 8) TORQUE ITEM 7 TO 13-16 FT-LBS (160-190 IN-LBS)
- 9) INSTALL ITEM 6 AND ITEM 8 HAND TIGHT
- 10) DO NOT FOLD COTTER PIN

A	NEW ISSUE		KPT
REV.	DESCRIPTION		ECN # BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. A	
MFG. APPR.	DP	SHEET 1 OF 6	
APPROVED	WJP	SCALE	
DATE 2019-10-02		NTS	
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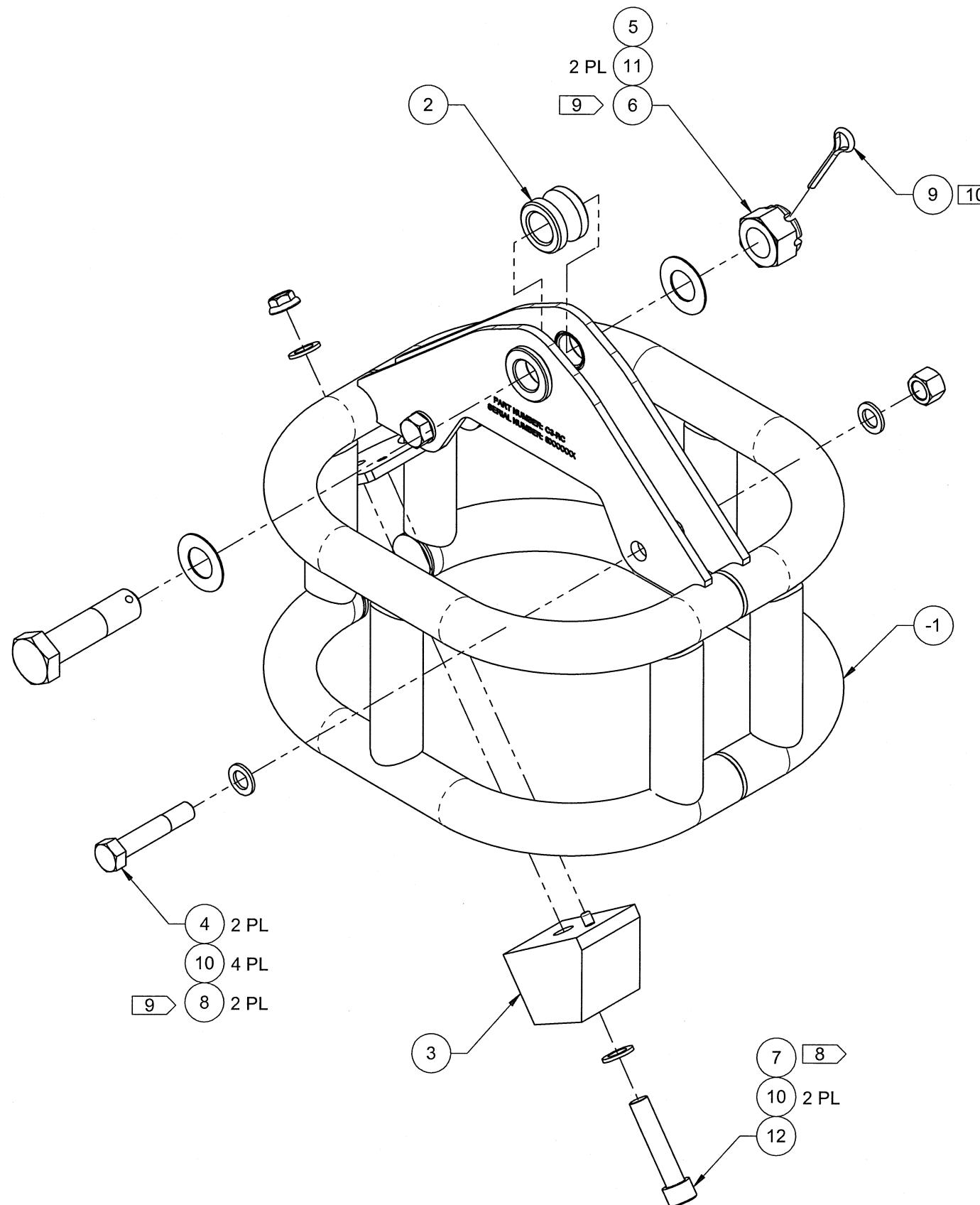
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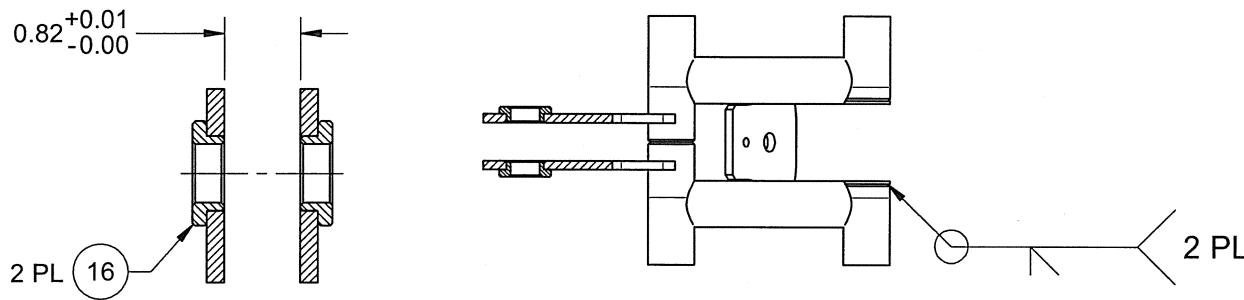
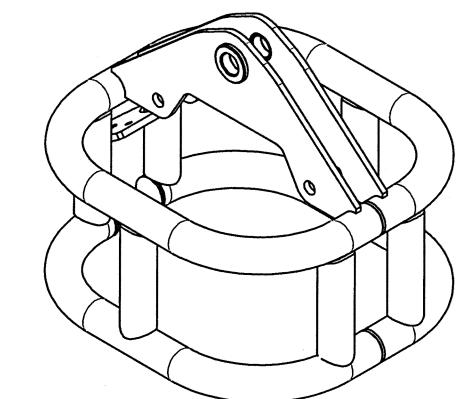
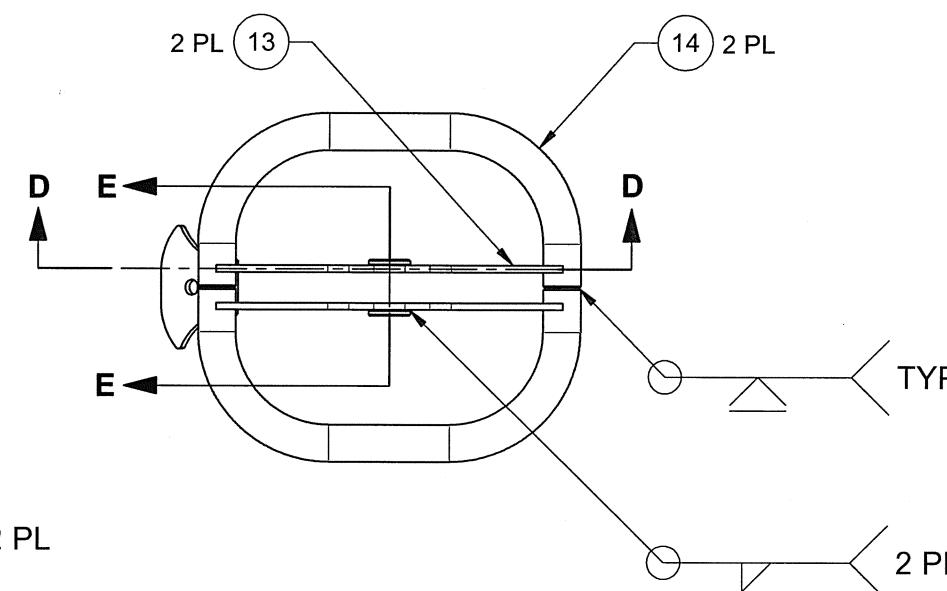
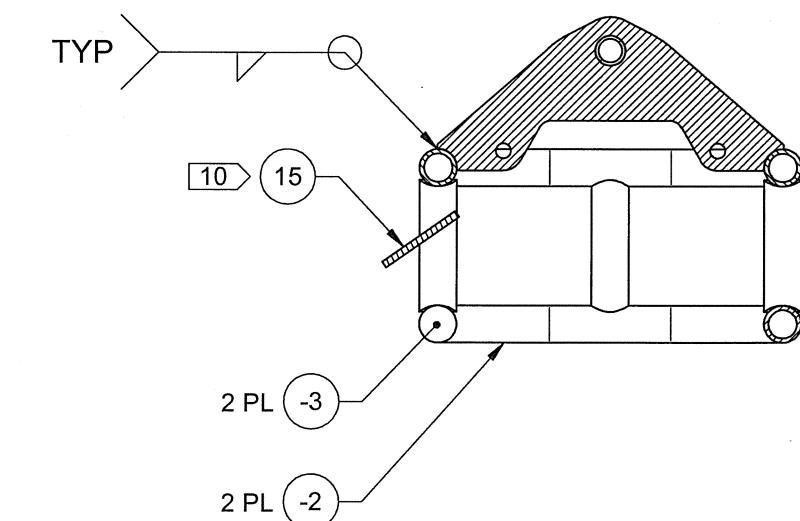
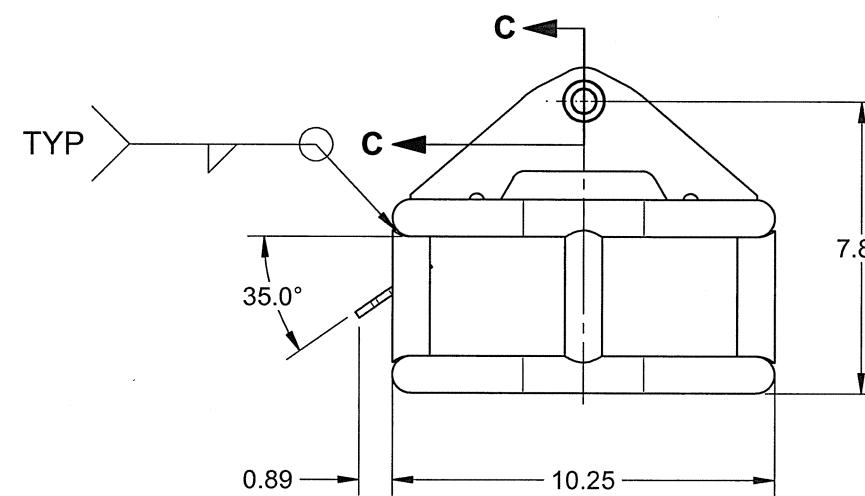
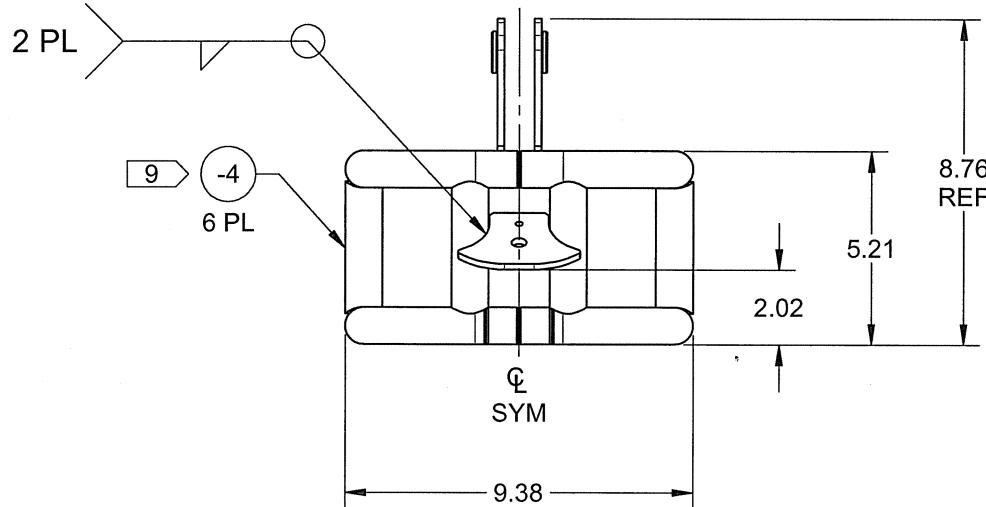


DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ZF	REV. A	
MFG. APPR.	DP	SHEET 2 OF 6	
APPROVED	<i>[Signature]</i>	SCALE	
DATE	2019-10-02	NTS	
TOOL PART #		C3-RC	
TITLE		C3 RING CAGE	

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ITEM #	QTY	PART #	PART TITLE
-2	2	C3-RC-2	BOTTOM SEMI-RING
-3	2	C3-RC-3	TUBE CAP
-4	6	C3-RC-4	STIFFENER BAR
13	2	C3-C-2	LIFTING PLATE
14	2	C3-C-3	TOP SEMI-RING
15	1	C3-C-6	BUMPER BRACKET
16	2	C3-C-7	BOSS

**SECTION E-E****SECTION C-C****C3-RC-1 C3 RING CAGE WELDMENT****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: PRIME AND PAINT RED AS PER QSI 005 SECTION 4.2.2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) REMOVE ALL SHARP EDGES, BURRS, AND WELD SPATTERS

9) NOTCH ENDS OF ITEM -4 AS REQUIRED, PRIOR TO WELDING

10) TRIM ITEM 15 AS REQUIRED TO MATCH PROFILE OF ITEM -4, PRIOR TO WELDING

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD
CHECKED ZF	REV. A	HAWKESBURY, ONTARIO, CANADA
MFG. APPR. DP	SHEET 3 OF 6	TOOL PART #
APPROVED	NTS	C3-RC
DATE 2019-10-02		TITLE C3 RING CAGE

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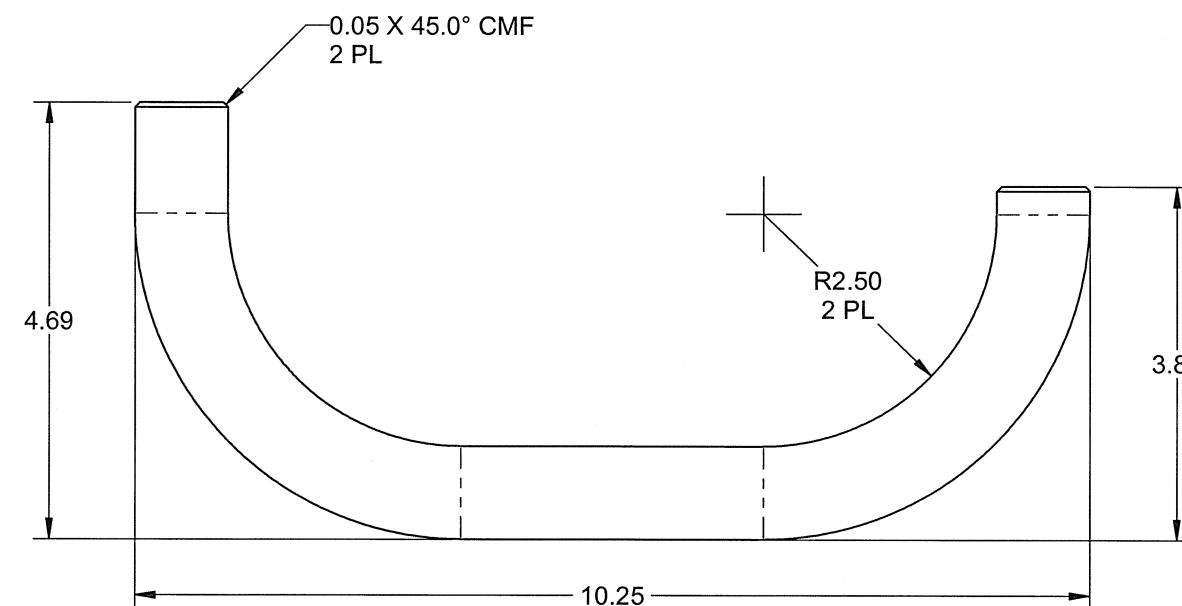
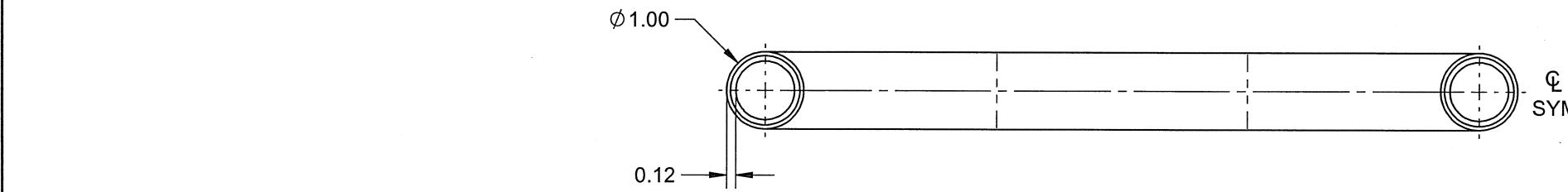
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C3-RC-2 BOTTOM SEMI-RING

NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED ZF	TOOL PART # C3-RC	REV. A
MFG. APPR. DP	TITLE C3 RING CAGE	SHEET 4 OF 6
APPROVED	SCALE NTS	NTS

DATE 2019-10-02

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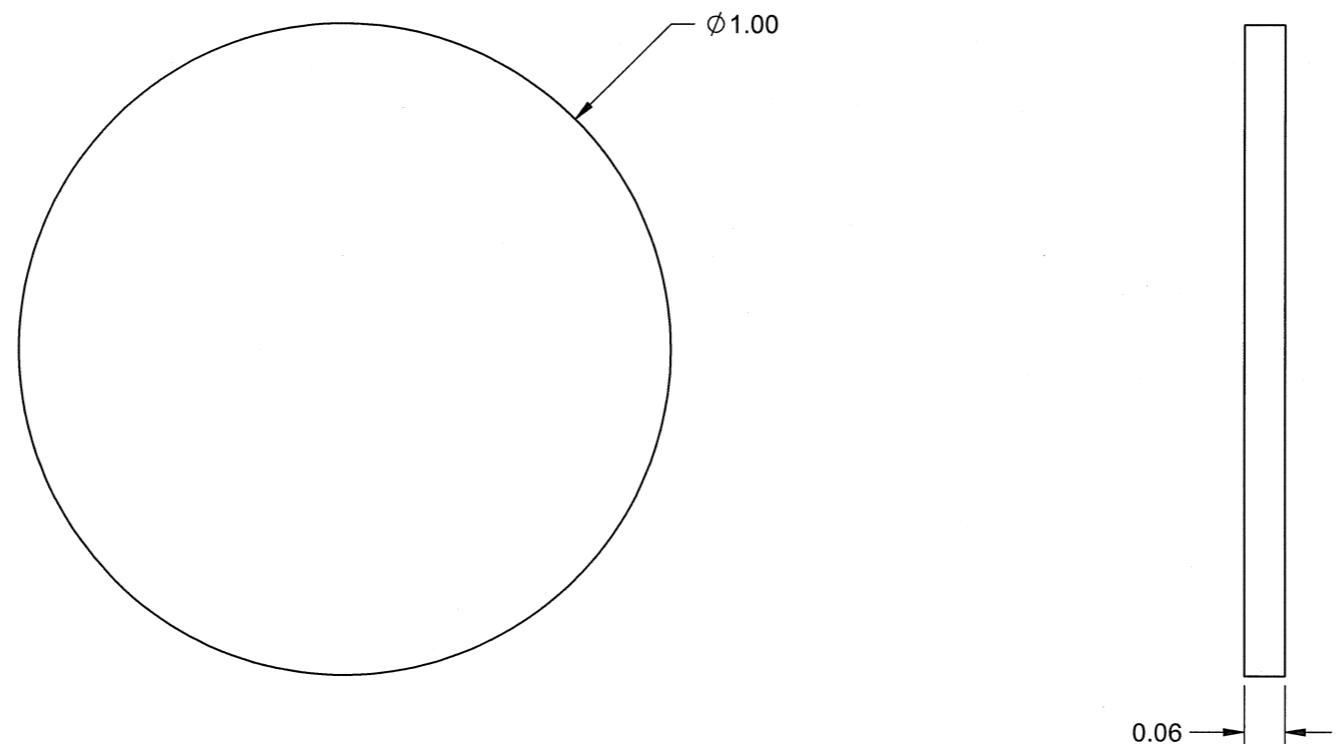
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C3-RC-3 TUBE CAP

NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	ZF	
MFG. APPR.	DP	REV. A
APPROVED	VIP	SHEET 5 OF 6
TOOL PART #	C3-RC	
TITLE	C3 RING CAGE	
DATE	2019-10-02	SCALE
		NTS

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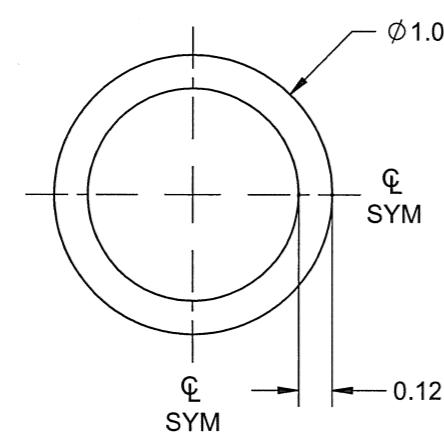
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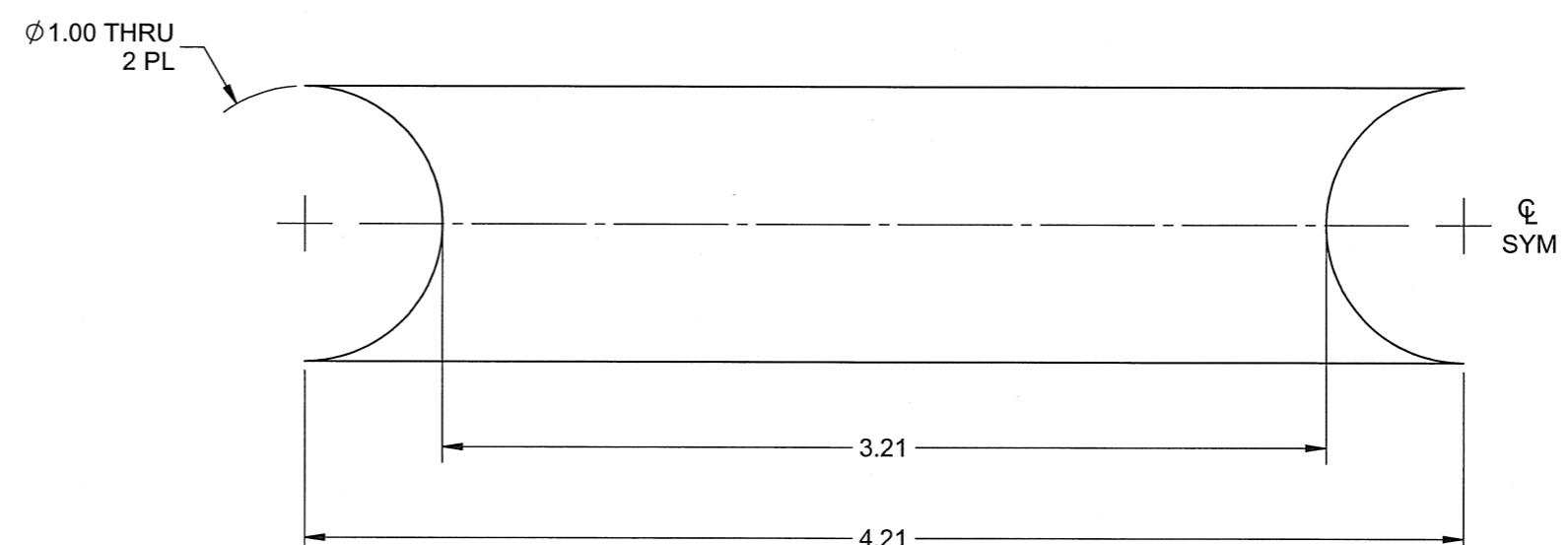
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C3-RC-4 STIFFENER BAR



NOTES:

- 1) MATERIAL: A513 TYPE 5 DOM TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	ZF	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	REV. A	
APPROVED	<i>WJ</i>	TOOL PART #	C3-RC
		TITLE	C3 RING CAGE
DATE 2019-10-02		SCALE	NTS
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